

InStruc® PCGF10MIN30HFMR

Americhem - Polycarbonate

General Information
Product Description

InStruc® PCGF10MIN30HFMR is a 10% glass fiber and 30% mineral reinforced polycarbonate. This product also has increased flow and mold release. InStruc® PCGF10MIN30HFMR offers toughness, creep resistance, and dimensional stability. The values on this datasheet are only theoretical.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight • Mineral, 30% Filler by Weight		
Additive	• Mold Release		
Features	• Filled • Good Dimensional Stability • Good Mold Release	• High Flow • High Stiffness • High Strength	• Lubricated
Uses	• Automotive Applications • Closures • Connectors • Consumer Applications	• Electrical/Electronic Applications • Engineering Parts • Household Goods • Housings	• Industrial Applications • Industrial Parts • Office Automation Equipment
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.55		ASTM D792
Molding Shrinkage - Flow	4.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	600000	psi	ASTM D638
Tensile Strength	9500	psi	ASTM D638
Tensile Elongation (Yield)	4.0 to 6.0	%	ASTM D638
Flexural Modulus	525000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.4 to 1.6	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Processing (Melt) Temp	580 to 620	°F
Mold Temperature	180 to 240	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

